

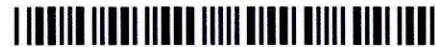


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

648.8711

Job Sheet 213454



Part No: 648.8711

Job Qty: 100 pcs

Part Name: Spring Stop



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/28/20

Job Tracking No:

Due Date: 10/9/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: 648.8700 REV.D IPP REV:A 20.09.25 NEW ISSUE DD VERF:FK

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	SL-154 - 1	100 pcs	10/9/20		0.50	33.33	Doosan - 1	
							Hardinge - 1	
							SL-154 - 1	IL 20-10-4
110	QC 2	100 pcs	10/9/20		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	IL 20-10-4
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	

Dart Aerospace Ltd.
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CANADA
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Container No: S304684



Part: 648.8711

Job No: 213454

Serial No/Batch: S304684

Revision: REV.D

Inspector:

Exp Date:

Instructions:

Date: 10/04/20

					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
120	QC 8	100 pcs	10/9/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	A. 20-10-14
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Packaging 3-1 - Stock - B4B	100 pcs	10/9/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	JRB
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	OCT 14 2020
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	100 pcs	10/9/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					Broussard
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

Part Op **100** - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** Machine as per folio F D 387 FOLIO REV: AA
 Descriptions: _____ DWG REV: D 2-Deburr
110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - Identify as per dwg & Stock
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	4 ft (.04 ea) (.043)	100-SL-154 - 1	<u>5302988</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M303R0.750	4	44	0

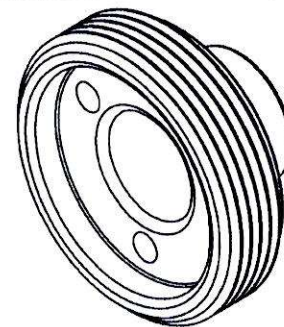
Part Specifications
Specifications could not be found.

Plex 9/28/20 9:18 AM dart.lacelle.linda

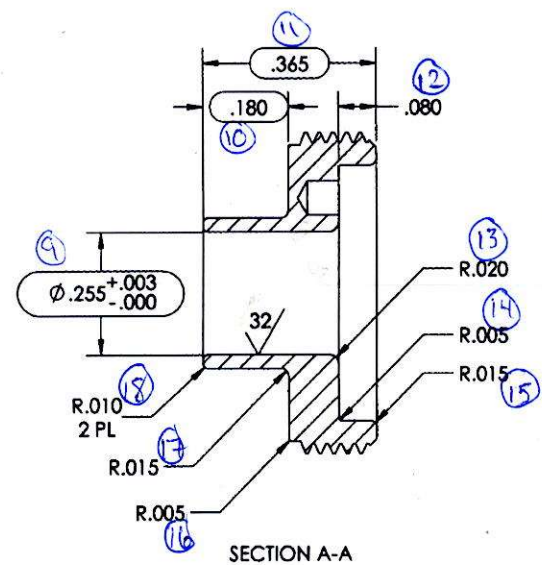
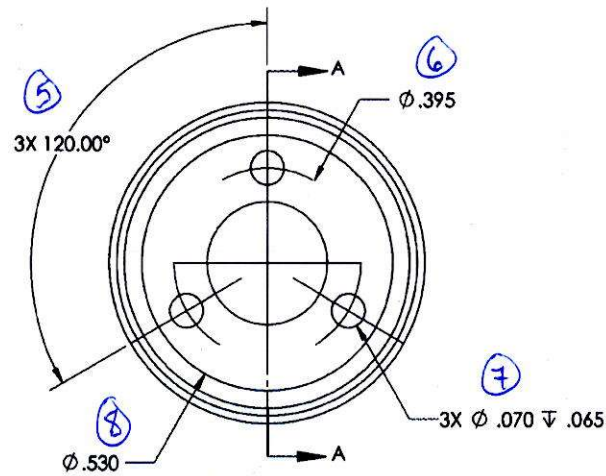
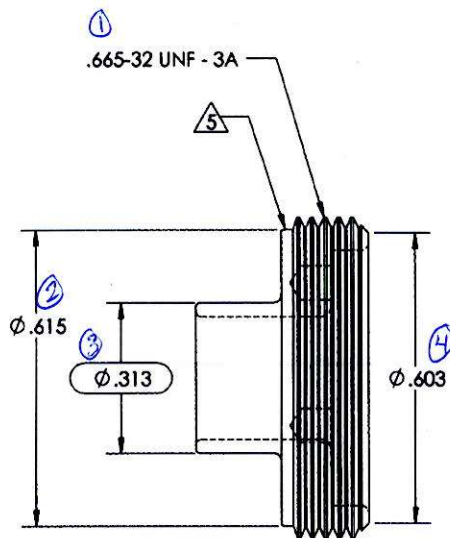
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Same as 650.7310



648.8711



ORIGINAL DATE 8/20/11 09:24:11		APICAL INDUSTRIES	
DRAWN BY N.CAP		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. MALVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL 09/22/11		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS $\pm .010$ 2 PLACE DECIMALS $\pm .005$ 3 PLACE DECIMALS $\pm .001$ ANGLES $\pm .5^\circ$		SHEET NO. B 07MAZ6	REV. D
SCALE NONE		648.8700	
		SHEET 2 OF 2	

David Duval

From: Jacob Becker
Sent: Friday, September 25, 2020 5:48 PM
To: David Duval; Steven Drouin
Cc: Alex Quan
Subject: RE: Sustaining issue for valve material spec

Yes, this is acceptable. It does not affect the function of the component.

Regards,

JACOB BECKER
Lead Sustaining Engineer

DART AEROSPACE
T 1 760 509-1639
M 1 760 691-9108

From: David Duval <dduval@dartaero.com>
Sent: Friday, September 25, 2020 2:05 PM
To: Jacob Becker <jbecker@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: Sustaining issue for valve material spec

Hi.
I would like to know if we could have a deviation made to add this material spec **303 SS ASTM A582** to the 648.8700 dwg.
As you know we are currently revising some of the valves dwg and we are adding in the material : **303 SS IAW AMS-5640 OR ASTM A582** to them.
I just wanted to know if this deviation could apply to this one also.

Thanks
David Duval
Production Engineering Supervisor

DART AEROSPACE
T 1 613 632-5200 ext : 234
F 1 613 632-1053
E dduval@dartaero.com
1 800 556- 4166
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DART AEROSPACE LTD		Work Order:	213454
Description: Spring stop		Part Number:	648-8711
Inspection Dwg: 648-8700		Rev: D	Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	665-32unF-3A		662	/		mic JL-9	
	major Ø: 662	±.003					
①	m.o.w: 6703	±.0015	670	/		--	
	wires .018						
②	615	±.005	613	/		VERV JL-2	
③	313	±.005	313	/		--	
④	603	±.005	603	/		--	
⑤	120°	±.5°	120°	/			
⑥	395	±.005	395.6	/		VERV JL-2	
⑦	Ø.07	±.005	.072	/		--	
⑧	T.065	±.005	.065	/		--	
⑨	530	±.005	531	/		--	
⑩	255	±.003 -0	256.5	/		g-PIN	
⑪	180	±.005	181	/		VERV JL-2	
⑫	365	±.005	365	/		--	
⑬	Ø80	±.005	Ø81	/		--	
⑭	R-020	±.005	.020	/			
⑮	R-005	±.005	.005	/			
⑯	R-015	±.005	.015	/			
⑰	R-005	±.005	.005	/			
⑱	R-015	±.005	.015	/			
⑲	R-010	±.005	.010	/			
	Ø	+0.000/-32	148	/		Surface Roughness Tester	
			see attached results				

Measured by: JL	Checked by: B.R.	QC Inspector:
Date: 20-10-14	Date: 20-10-14	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	